

Date: Thursday, 4/5/2007 11:59:13 AM  
User: Kim Johnston

## Process Sheet

Split *for 06/28*

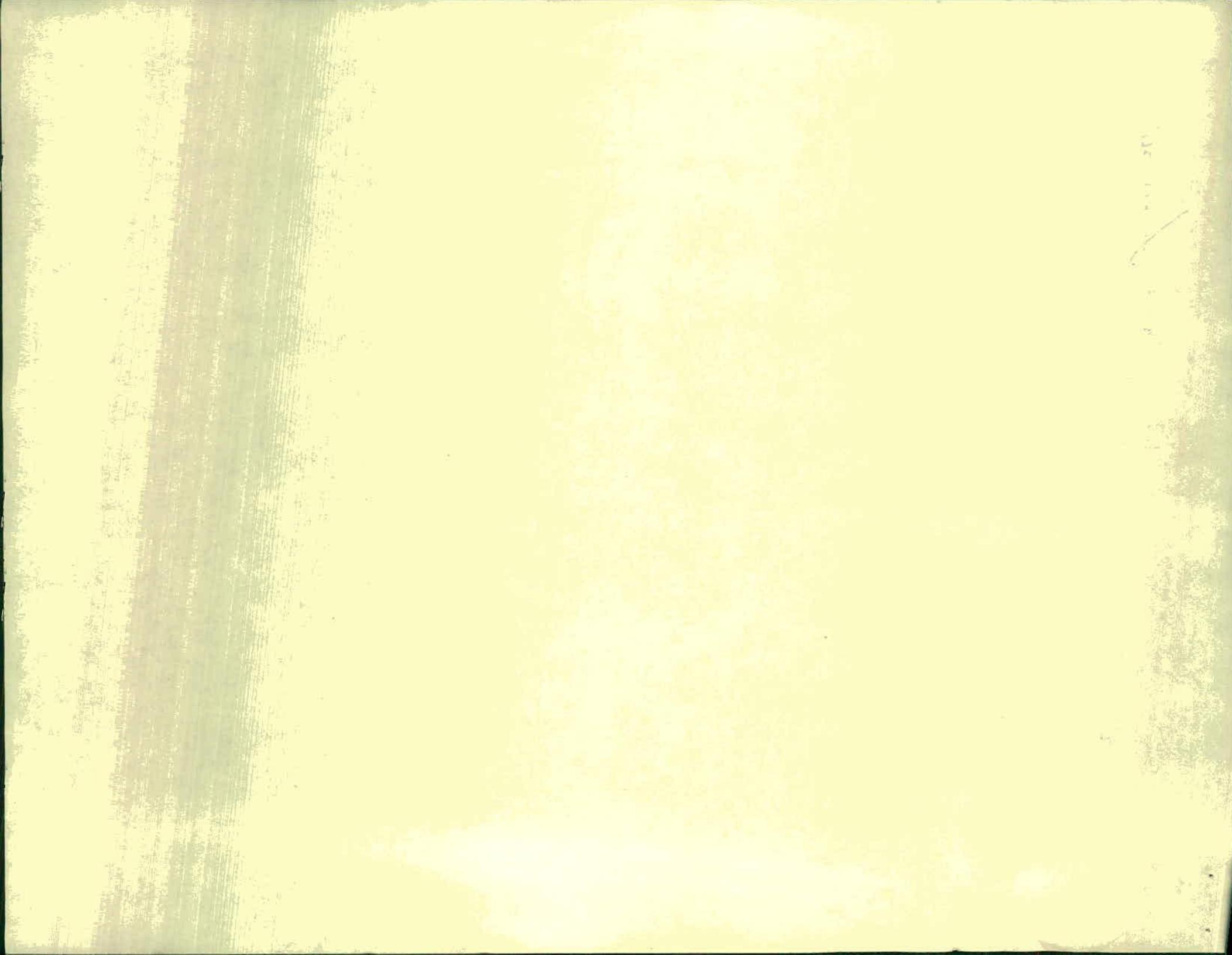
Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)		
Job Number	: 31694-2	Part Number	: D2332041		
Estimate Number	: 10258			Drawing Number	: D2332 REV C1
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 4/5/2007	S.O. No.	: N/A		
Frst Rev.	: NC	Type	: SMALL /MED FAB		
First Issue	: N/A	Material	: N/A		
Previous Run	: 31105	Due Date	: 5/5/2007 Qty: 20 Um: Each		
Written By	:				
Checked & Approved By	:				
Comment	: Est: B 02-08 12 Re-format; Incorporated D2332-13-11/7-5 K J/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M304TR1000W049	304 RD Tube 1.0" x .049W	
		Comment: Qty.: 0.4368 f(s)/Unit Total: 8.7360 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless)	Batch <i>(RE) M103240 (RE)</i>
2.0	M304R250	1/4" 304 SS Roundbar	
		Comment: Qty.: 0.1092 f(s)/Unit Total: 2.1840 f(s) Material: Ø0.250" 304SS Rod	Batch <i>PTC 07/04/29</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	<i>20</i>
		1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar	<i>PTC</i>
		2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin	<i>07/06/25</i>
		3-Deburr	<i>07/06/25</i>
4.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.2080 f(s)/Unit Total: 24.1600 f(s) 304 RD Tube .500 x .035W	<i>Batch 103982 M104640</i>



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Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Batch: M103487

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

FF 07-04-26

4

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

M103487

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

- Ensure to remove foreign objects.

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M102756

100% 07/04/21

do

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

100% 07/04/21

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

100% 07/06/27 (70) counted

100% 07/06/27 (70)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1



1-Tumble

①

2-Assemble as per Dwg D2332

50% 07/06/28

②

10.0 AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

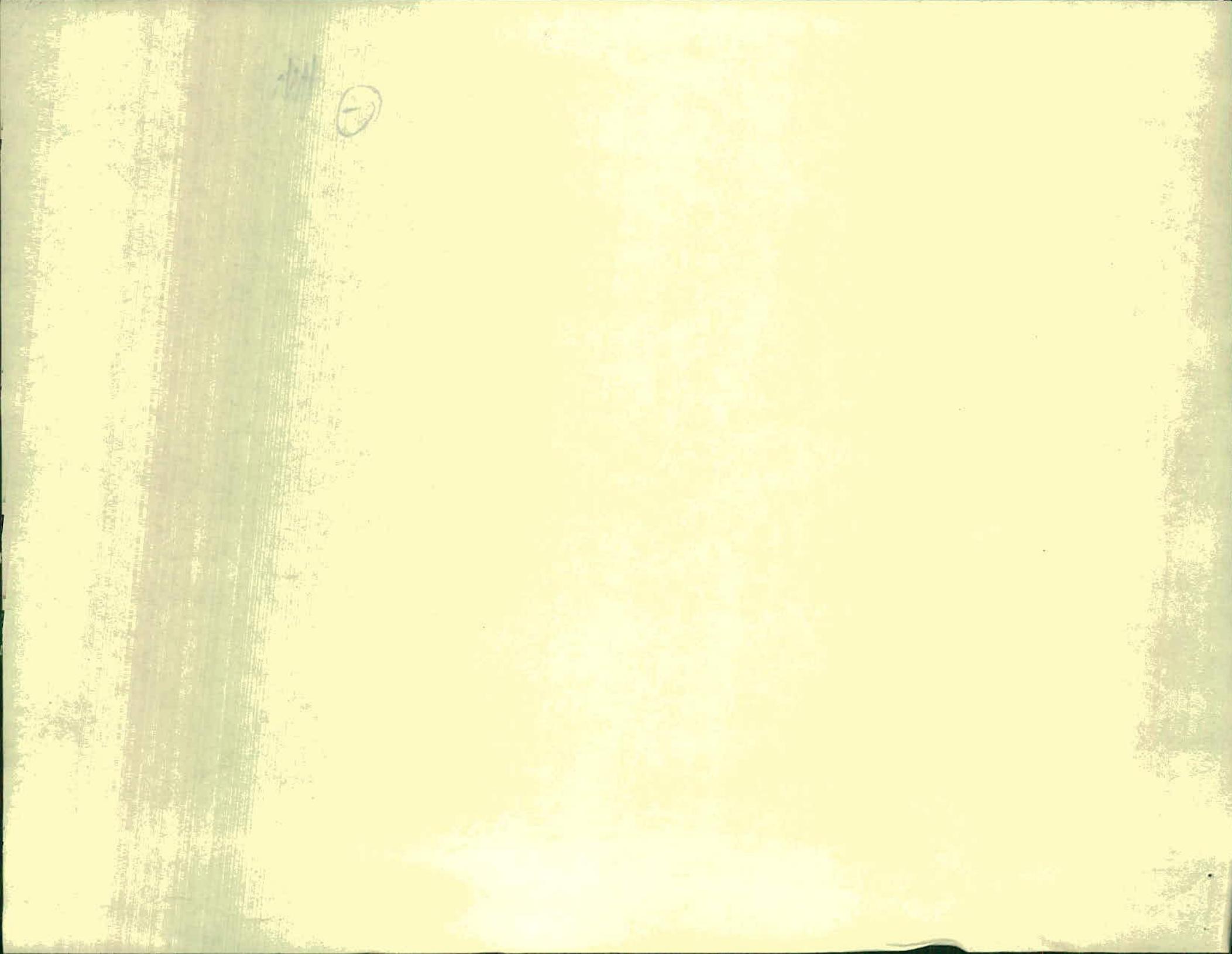
Description

Batch

1 AN4-4A

Bolt

M101291



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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	H104214

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	H102552

SAD

07/06/23

(29)

13.0

QC5

INSPECT WORK TO CURRENT STEP



JUL 28 ①



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



JUL 28 ①



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A far assembly rush

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

① 07/06/28

Job Completion



① JUL 28

